

Work Order ID 60455

Page 1

Friday, July 09, 2010 9:53:57 AM

Item ID: D3762-041

Accept



Setup Start



Revision ID:

Item Name: Front Leg Fitting Assembly

Stop



Start Date: 7/12/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-7-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3762	Rev A

100 Pick Kit



0.00

EL 10-8-4

Packaging

Memo

0.00

Packaging

110



Large Fab

0.00

EL 10-8-4

Large Fab

Memo

0.00

(X8)

1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place

2-take pins out before welding

3-weld as per dwg D3762 per QSI004

Alum. rod Batch: M 114242

W/O:		WORK ORDER CHANGES							
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Date:

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Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool

ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
Number

Insp.

Stamp

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

x8 0 BE 10/08/05

QC

Quality Control

130



QC5- Inspect part completeness to step on W/O

0.00

Sucess

(78)

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

U

10/08/05

V8 - 6

HandFinish

Hand Finishing

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Setup Start



Stop



QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
Description

150



QC

Quality Control

160



Packaging

Packaging

170



QC

Quality Control

Identify as per dwg & Stock Location 251

0.00

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
Description

150



QC

Quality Control

160



Packaging

Packaging

Identify as per dwg & Stock Location 251

0.00

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Sequence ID/
Work Center IDOperation
Description

150



QC

Quality Control

160



Packaging

Packaging

Identify as per dwg & Stock Location 251

0.00

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Sequence ID/
Work Center IDOperation
Description

150



QC

Quality Control

160



Packaging

Packaging

Identify as per dwg & Stock Location 251

0.00

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Sequence ID/
Work Center IDOperation
Description

150



QC

Quality Control

160



Packaging

Packaging

Identify as per dwg & Stock Location 251

0.00

0.00

QC21- Final Inspection - Work Order Release

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Memo

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Work Center IDOperation
Description

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QC

Quality Control

160



Packaging

Packaging

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QC

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Packaging

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QC

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Packaging

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Packaging

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QC

Quality Control

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Packaging

Packaging

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QC21- Final Inspection - Work Order Release

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Memo

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QC

Quality Control

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Packaging

Packaging

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0.00

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Memo

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QC

Quality Control

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Packaging

Packaging

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0.00

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Memo

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QC

Quality Control

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Packaging

Packaging

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QC21- Final Inspection - Work Order Release

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Sequence ID/
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QC

Quality Control

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Packaging

Packaging

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Memo

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QC

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Packaging

Packaging

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Memo

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QC

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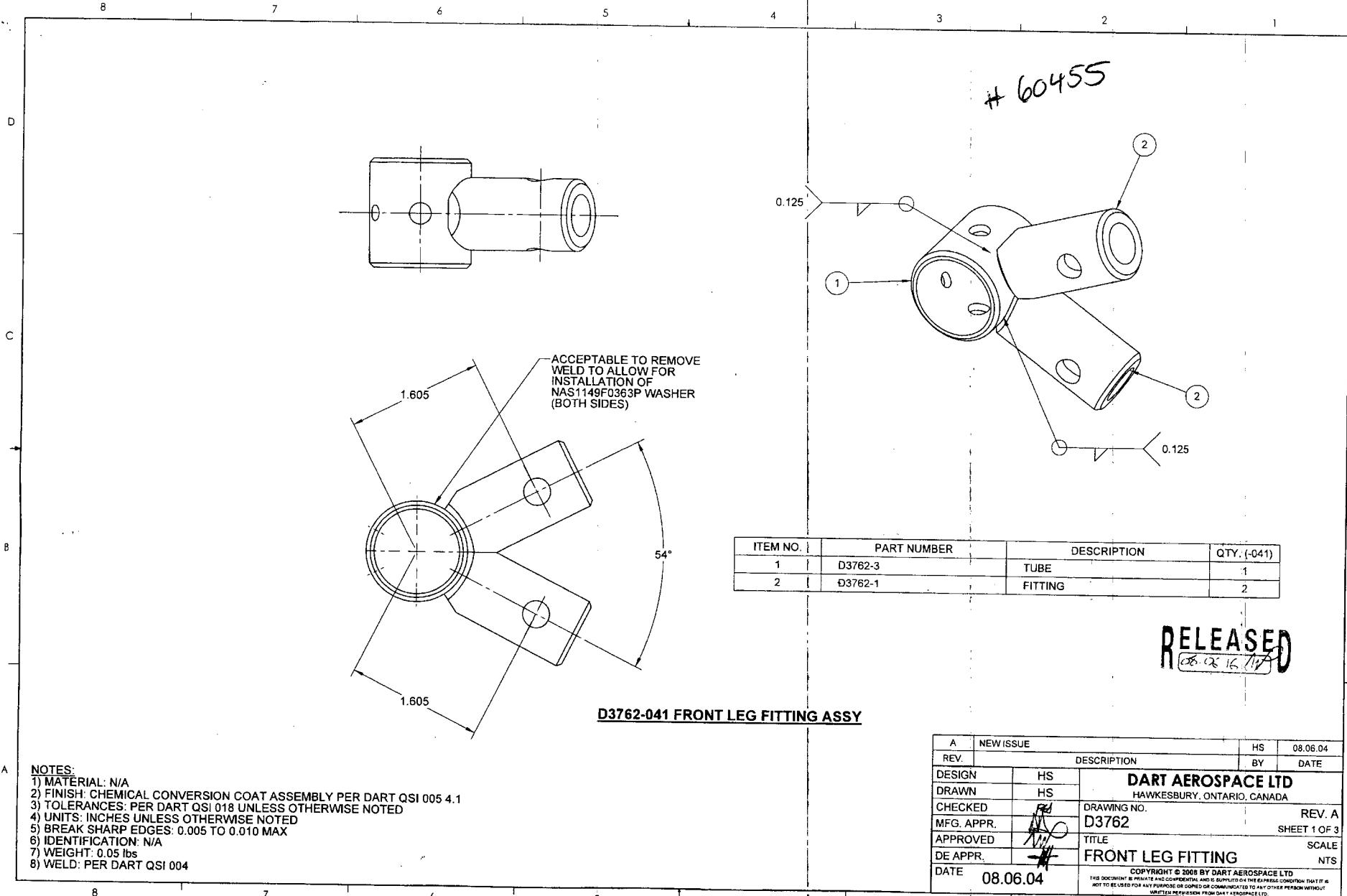
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A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	HS	DRAWING NO.	REV. A	
CHECKED	FD	D3762	SHEET 1 OF 3	
MFG. APPR.	AP	TITLE	SCALE	
APPROVED	AM	FRONT LEG FITTING	NTS	
DE APPR.	AM			
DATE	08.06.04			

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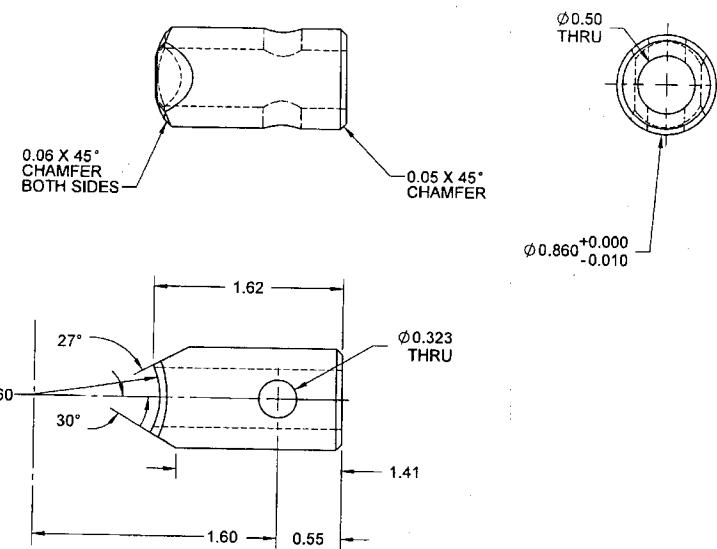
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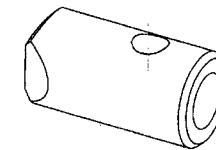


D3762-1 FITTING

A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

#60455



RELEASED
08-06-14 AM

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PAT</i>	DRAWING NO.	
MFG. APPR.	<i>JM</i>	REV. A	
APPROVED	<i>JM</i>	SHEET 2 OF 3	
DE APPR.	<i>JM</i>	TITLE	SCALE
DATE	08.06.04	FRONT LEG FITTING	NTS
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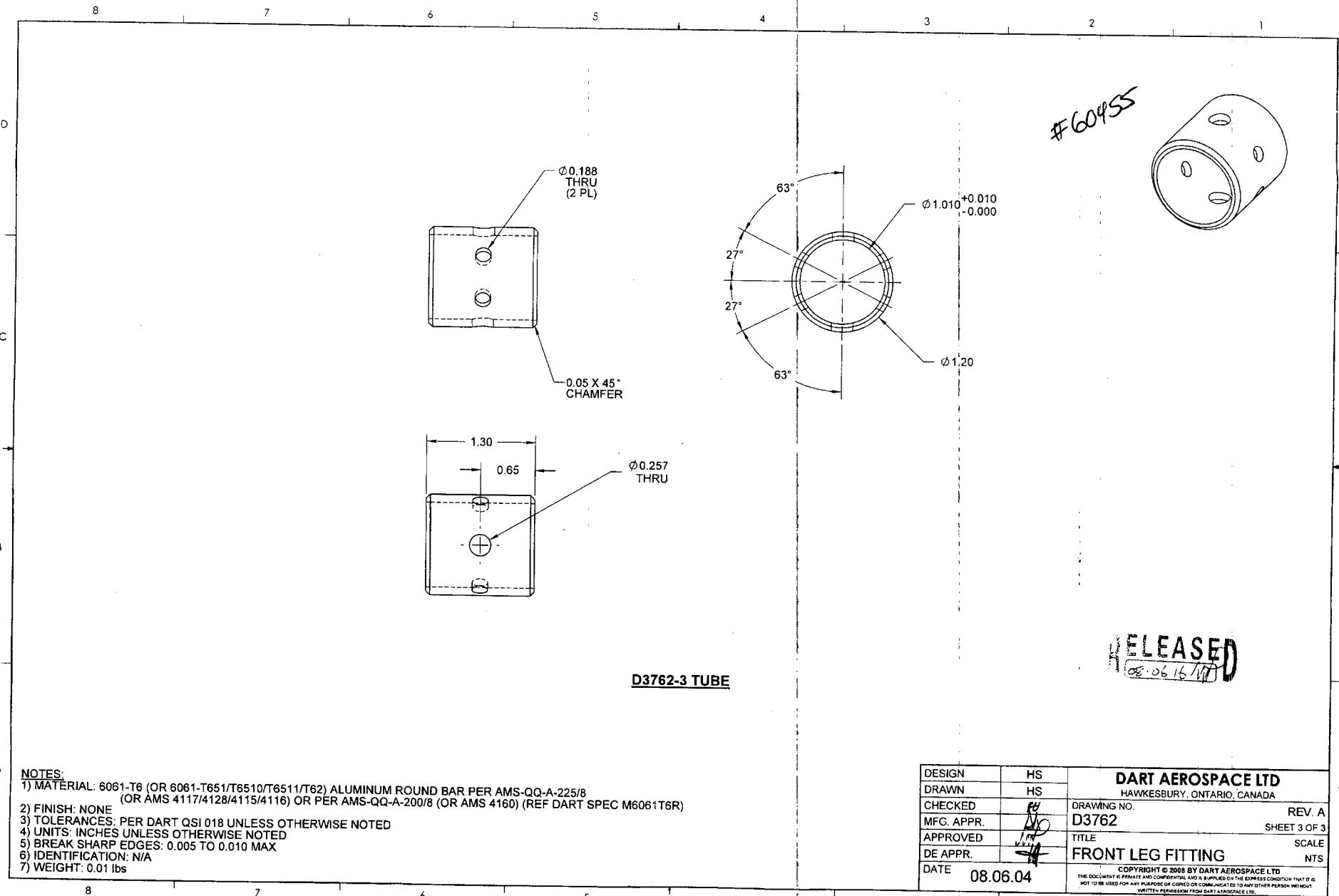
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